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Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D2274**Job Sheet 173351****Part No:** D2274**Job Qty:** 210 ea**Part Name:** Radius Block**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 2/28/18**Job Tracking No:****Due Date:** 3/19/18**Created By:** Logan David**Type:** Stock**Description:****Note:** DWG REV F IPP H 00.05.18 Added inspection level 8 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	210 Ea		3/17/18	0.00	0.00	Start Up Large Fab-7		
100	Shear	210 pcs		3/17/18	0.00	0.10	Shear		
110	CNC Vertical Machining	210 pcs		3/17/18	0.01	5.03	HAAS 1		
130	QC	210 pcs		3/17/18	0.00	0.00	QC8		
140	Small Fab	210 pcs		3/17/18	0.00	1.14	Small Fab		
150	HandFinish	210 pcs		3/19/18	0.00	0.54	HandFinish1		
160	QC	210 pcs		3/19/18	0.00	0.00	QC7		
170	Packaging	210 pcs		3/19/18	0.00	0.00	Packaging3		
180	QC21-SA	210 Ea		3/19/18	0.00	0.00	QC21		

Part Op 100 - blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
 Descriptions: 110 - Machine as per folio D2274
 140 - Tumble Deburr any rough edges after tumbling

DAS
21
9-80

APR 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.125	6061-T6 Bar .750 X .125	17.8500 ft (.085 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X00.125	18	99	0

CART
AEROSPACE
Container No: S054501
Part: D2274
Job No: 173351
Serial No/Batch: S054501
Revisor:
Inspector:

Date: 03/23/18

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		
6	Radius Block	0.063inches ± 0.010	0.073 0.053		

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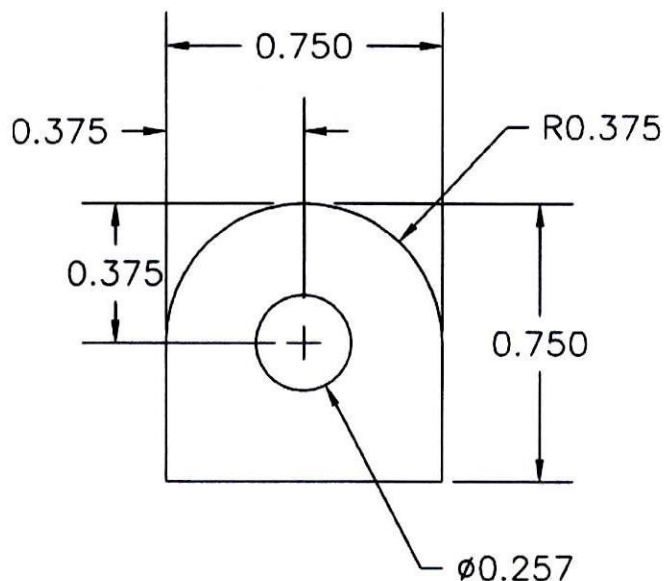
DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MP</i>	APPROVED <i>JS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173351 *7L*

20180301



EC 00.05.16
AF 00.05.16
0.063 x 45° CHAMFER
~~R0.0 - 0.13~~

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED